

Date: Friday, 25/04/2008 11:39:14 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
 Job Number : 38797
 Estimate Number : 10258
 P.O. Number :
 This Issue : 25/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 25/04/2008 Type : SMALL /MED FAB
 Previous Run : 38597
 Written By :
 Checked & Approved By : JLD 08.4.25
 Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/
 RF

Part Number : D2332041
 Drawing Number : D2332
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 05/05/2008 Qty: 21 Um: 20 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR1000W049 304 RD Tube 1.0" x .049W



Comment: Qty.: 0.4331 f(s)/Unit Total : 8.6625 f(s)
 Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

M107950

EB08/05/09 Batch

2.0 M304R250 1/4" 304 SS Roundbar



Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)

Material: Ø0.250" 304SS Rod

Batch M105950 (19X)

M107387 (2X) EB

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

EB08/05/09 (2X)

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

EB08/05/05 (21X)

3-Deburr

EB08/05/02 (21X)

4.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 1.2502 f(s)/Unit Total : 25.0040 f(s)

304 RD Tube .500 x .035W

M107166

SB 08/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

21 08/05/06 (21)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. (Drill 1 per assembly)
2-ensure no foreign objects inside fo tube and deburr

21 08/05/06 (21)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

21 08/05/06 (21) (21) (21) (21)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly) *****
insure nothing is inside of tube before welding*****

21 2

A/R SS Rod Batch: M107051

08-05-15

sp.

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

21 08-05-16 (21)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

21 08/05/16 (21) (21) (21)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

* DIT 08/05/16 (21)

2-Assemble as per Dwg D2332

21 08/05/20 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M106918

CB08/05/20

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

M107008

CB08/05/20

14.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

M106051

CB08/05/20

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/20 (x21)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 203

AS 08/05/20 (x21)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/20

Job Completion



mf 08-05-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

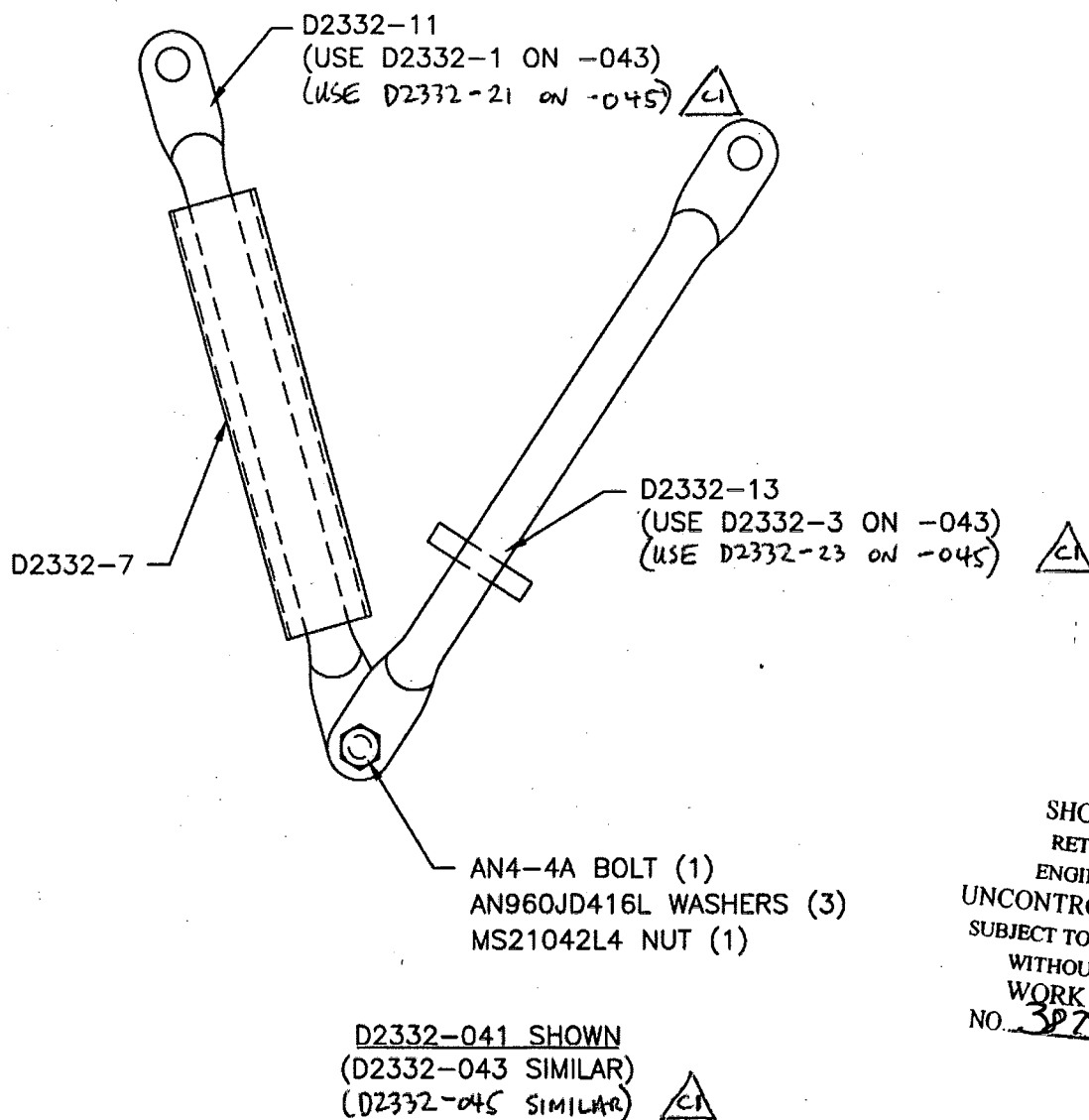
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
CI	<i>[initials]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 *[initials]*

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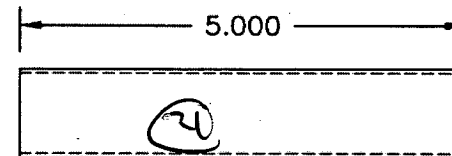
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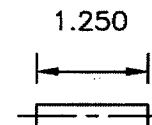
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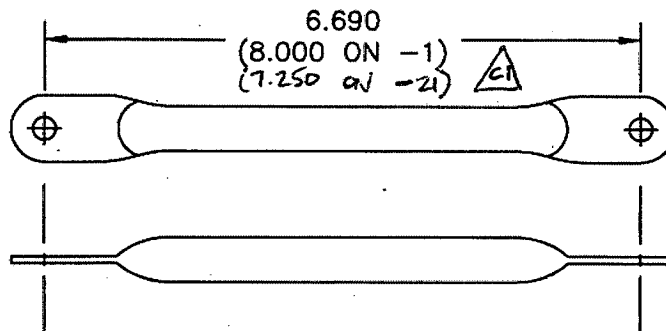
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2332	REV. C
DATE 03.07.03		TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2	
C	<i>[Signature]</i> 03.07.03	MAKE - 041 PROP 6.69" LONG (END)	
C1	<i>[Signature]</i> 03.08.06	MAKE - 043 PROP 8.00" LONG (INT)	
		ADD - 045 PROP (7.25" LONG)	



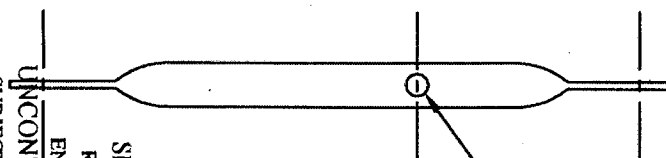
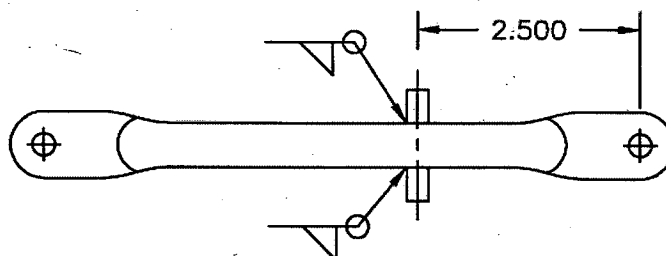
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.01.04

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